

Date: Wednesday, 4/19/2006 1:08:35 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHIM
Job Number : 26739	
Estimate Number : 10915	
P.O. Number : N/A	Part Number : D34421
This Issue : 4/19/2006 S.O. No. : N/A	Drawing Number : D3442 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <u>See Comment Below</u>	Due Date : 4/26/2006
Checked & Approved By : <u>06.04.19</u>	Qty: <u>50</u> Um: <u>100</u> Each
Comment : Est. A 05.09.02 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 1043

Email or Ship DXF file to vendor

Laser Cut flat pattern per Dwg D3442

Possible Supplier: Industrial Laser

Material release note is required

C 206104120 (100)

2.0	D34421F	Shim
-----	---------	------



Comment: Qty.: 1.0000 U(s)/Unit Total : 100.0000 U(s)
 Shim

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

C 206104120 (100)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

C 206104120 (100)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WLS

C 206104120 (100)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/03/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/19/2006 1:08:35 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHIM

Job Number: 26739

Part Number: D34421

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Handwritten: 33
10/05/04

Job Completion



Handwritten: U D60504

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

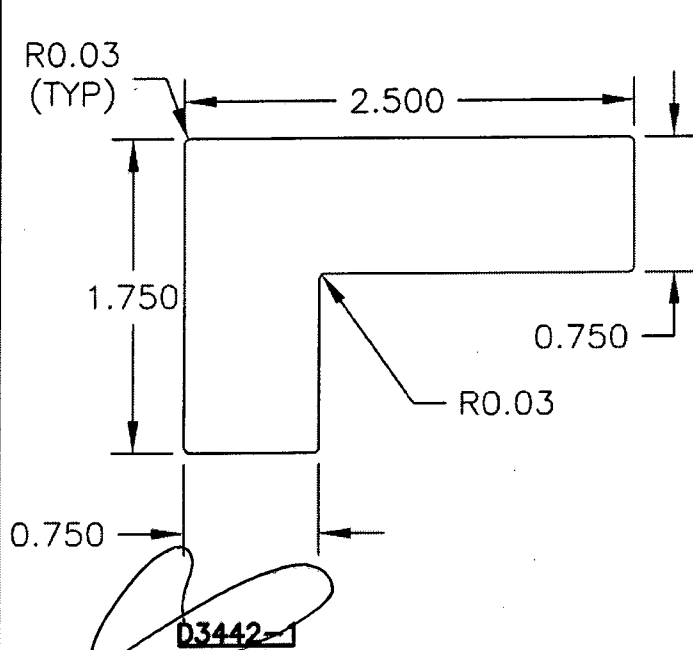
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

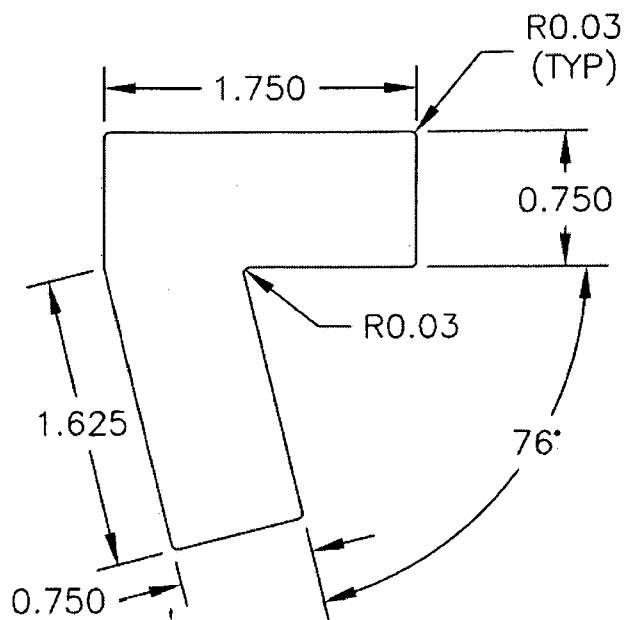


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3442	REV. A SHEET 1 OF 1
DATE 05.06.03		TITLE SHIM	SCALE 1:1
A	05.06.03	NEW ISSUE	

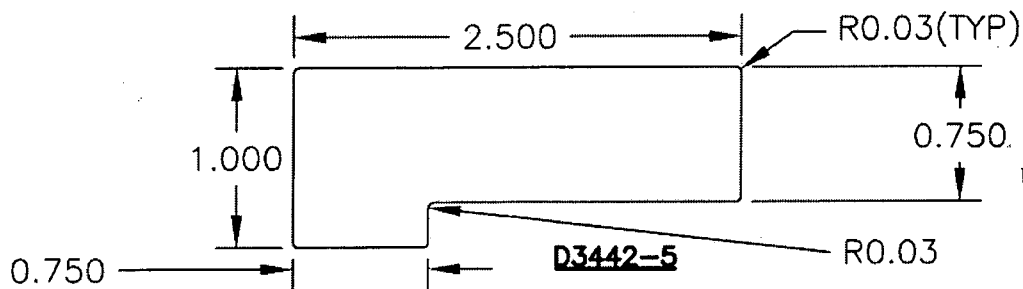


D3442-1/-3 SHIM

- 1) MATERIAL: AISI 304/316 SS SHEET 21 GAUGE (0.034 THICK)
(REF DART SPEC M304S21GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3442-3



D3442-5 SHIM

- 1) MATERIAL: AISI 304/316 SS SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26739

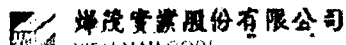
RELEASED

05.08.19 *[Signature]*

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MATERIAL TEST/INSPECTION CERTIFICATE



YIEH MAU CORP.
INVOICE NO. : F05MB11
COMMODITY : PRIME COLD ROLLED STAINLESS STEEL SHEET

90270957

工廠:高雄路竹鄉順安路345號
345, SEW AN RD, LU CHU KSLANG
KAHSIUNG TAIWAN R.O.C.
TEL: (07) 6972385 FAX: (07) 6973006
CERTIFICATE NO. F05MB11
DATE OF ISSUE: 12/30/2005
PAGE 2/3

SPECIFICATION : AISI 304
CUSTOMER : INTEGRIS METALS LTD.

ITEM NO.	SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test CL=50 mm					Chemical Composition (%)							
			KGS	LBS			Y _S (N/mm ²)	T _S (N/mm ²)	E _L (%)	HRB	HV	C x100	Si x100	Mn x100	P x1000	S x1000	N x100	Cr x100	N x100
AISI 304, NO.4 (SIC) FINISH, WITH 100 MIC. FILM ON MAIN SIDE, WITH BACK-PASS, SLITTED EDGE.																			
7425-3530	18GA\48"X144"	1	1,435	3,164	YU138523	4BS18564-12	296	655	53	89	164	4.6	51	99	33	5	806	1896	2.2
7425-3539	18GA\60"X120"	1	1,424	3,139	YU137844	4BS16469A-11	308	701	50	88	165	4.7	50	117	31	5	804	1813	3
7425-6159	16GA\48"X 96"	1	1,445	3,186	YU189710	4BS18697-14	297	639	52	84	168	3.6	49	110	34	3	812	1818	3.2
7425-6159	16GA\48"X 96"	1	1,445	3,186	YU138710	4BS18697-15	297	639	52	84	168	3.6	49	110	34	3	812	1818	3.2
7425-6159	16GA\48"X 96"	1	1,445	3,186	YU139710	4BS18697-16	297	639	52	84	168	3.6	49	110	34	3	812	1818	3.2
7425-6288	16GA\48"X120"	1	1,462	3,223	YU139710	4BS18697-17	297	639	52	84	168	3.6	49	110	34	3	812	1818	3.2
7425-6288	16GA\48"X120"	1	1,462	3,223	YU139710	4BS18697-18	297	639	52	84	168	3.6	49	110	34	3	812	1818	3.2
7425-6288	16GA\48"X120"	1	1,464	3,225	YU139710	4BS18697-19	297	639	52	84	168	3.6	49	110	34	3	812	1818	3.2
7425-6343	16GA\60"X 96"	1	1,440	3,176	YU140033	4BS18975B-11	295	674	51	84	168	3.8	49	116	32	11	806	1804	2.7
7425-6353	16GA\60"X120"	1	1,418	3,125	YU140033	4BS18975B-16	295	674	51	84	168	3.8	49	116	32	11	806	1804	2.7
7425-6353	16GA\60"X120"	1	1,195	2,635	YU140033	4BS18975B-17	295	674	51	84	168	3.8	49	116	32	11	806	1804	2.7
7425-6363	16GA\60"X144"	1	1,375	3,031	YU140033	4BS18975B-12	295	674	51	84	168	3.8	49	116	32	11	806	1804	2.7
7425-6363	16GA\60"X144"	1	1,374	3,029	YU140033	4BS18975B-13	295	674	51	84	168	3.8	49	116	32	11	806	1804	2.7
7425-9049	14GA\48"X120"	1	1,426	3,144	YU140207	4BS20605A-11	314	704	49	86	175	5.5	51	125	35	9	808	1818	1.8
7425-9049	14GA\48"X120"	1	1,421	3,133	YU140207	4BS20605A-12	314	704	49	86	175	5.5	51	125	35	9	808	1818	1.8
7425-9049	14GA\48"X120"	1	1,421	3,133	YU140207	4BS20605A-13	314	704	49	86	175	5.5	51	125	35	9	808	1818	1.8
7425-9285	14GA\60"X120"	1	1,442	3,179	YU140018	4BS19451A-11	306	672	50	83	173	4.9	47	118	32	10	804	1830	2.8
7427-4844	12GA\48"X120"	1	1,862	4,003	YU236779	4BS16846A-113	308	641	53	84	168	4.6	48	118	35	4	814	1823	3.4
7427-4844	12GA\48"X120"	1	1,862	4,003	YU236779	4BS16846A-114	308	641	53	84	168	4.6	48	118	35	4	814	1823	3.4
7427-7186	11GA\48"X 96"	1	1,473	3,247	YU140191	4BS20468A-113	300	673	52	84	167	4.8	53	127	32	5	804	1806	3.1
7427-7186	11GA\48"X 96"	1	1,473	3,247	YU140191	4BS20468A-114	300	673	52	84	167	4.8	53	127	32	5	804	1806	3.1
7427-7177	11GA\48"X120"	1	1,308	2,884	YU236346	4BS20446A-211	293	655	51	83	162	4.1	49	124	33	7	810	1817	3
7427-7177	11GA\48"X120"	1	1,313	2,890	YU236346	4BS20446B-110	293	655	51	83	162	4.1	49	124	33	7	810	1817	3
7427-7177	11GA\48"X120"	1	1,312	2,892	YU236346	4BS20446B-116	293	655	51	83	162	4.1	49	124	33	7	810	1817	3
7427-7177	11GA\48"X120"	1	1,310	2,901	YU140191	4BS20488B-211	300	673	52	84	167	4.8	53	127	32	5	804	1806	3.1
7427-7177	11GA\48"X120"	1	1,316	2,901	YU140191	4BS20488B-212	300	673	52	84	167	4.8	53	127	32	5	804	1806	3.1
7426-8430	18GA\36"X144"	1	1,458	3,203	YU236224	4BS20818-114	306	662	54	84	168	4.2	52	128	33	8	802	1815	3.3
7426-8420	12GA\36"X:14"	1	1,453	3,203	YU236224	4BS22616-116	305	655	54	84	163	4.2	52	128	33	8	802	1815	3.3
			26	59,255	56,499														

2E 98.983 56.499

Remarks: NO MERCURY CONTAMINATION
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.

- PRIME MATERIAL, NO DINGS, NO DENTS, NO SCRATCHES
- P.O. NO. 487684 (VANCOUVER)
- SALES CONTRACT NUMBER: F05MB11
- DOCUMENTARY CREDIT NUMBER: ILCMSP003165

YIEH MAU CORP.

in Kuan Hsin
Manager of Quality Assurance



P60124PC001

Shanxi Taiyuan Stainless Steel CO.,LTD Member
of Taiyuan Iron and Steel (Group) Co.,LTD

NO.2 jiancaoping, Taiyuan, Shanxi, P.R.China

TEL: (0351)3013328 FAX: (0351)3017816

http://www.tisco.com.cn

E-mail: tgbxg@tisco.com.cn

MILL TEST CERTIFICATE

MATERIAL	AISI304 No.2B Finish	
SPECIFICATION	ASTM A240/A480	ASME SA240/SA480
L/C NO.		
CERTIFICATE NO.	20051187	
DATE OF ISSUE	11	

CUSTOMER

OLBERT

CONTRACT NO.

1187

DATE OF

2005/11/20

Product

Melting furnace

Inspector's stamp

Mark of the Manufacturer

COIL

E+VOD



Shanxi Taiyuan Stainless Steel Co.,Ltd

NO.	Heat No.	Coil No.	Quantity	Dimensions	Weight (kg)
8	4505286	5A9-495-12D	1	11GA x 48 x C	7009
9	Y506019	5A9-485-12B	1	11GA x 48 x C	6679
10	4505044	5A9-456-12Y	1	14GA x 48 x C	5461
11	4505274	5A9-450-12D	1	11GA x 48 x C	4832
12	4505271	5A10-44-32J	1	16GA x 48 x C	8906
13	4505050	5A10-53-32J	1	16GA x 48 x C	8617
14	4505393	5A10-70-42Y	1	14GA x 48 x C	8642

Chemical Composition

Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	N
4505286	0.060	0.470	1.400	0.017	0.003	18.170	8.020	0.010	0.010	0.010	0.035
Y506019	0.050	0.350	0.990	0.032	0.004	18.300	8.090	0.440	0.006	0.120	0.070
4505044	0.060	0.450	1.370	0.018	0.002	18.200	8.120	0.010	0.010	0.010	0.030
4505274	0.060	0.320	1.320	0.017	0.002	18.150	8.120	0.010	0.010	0.010	0.043
4505271	0.060	0.470	1.320	0.016	0.003	18.170	8.110	0.010	0.010	0.010	0.043
4505050	0.050	0.480	1.290	0.014	0.002	18.220	8.040	0.010	0.010	0.010	0.045
4505393	0.070	0.480	1.260	0.017	0.002	18.200	8.070	0.010	0.010	0.010	0.040

Mechanical Properties

Test No.	Tensile Rm N/mm ²	R _{p0.2} Yield _{0.2%} N/mm ²	R _{p1.0} Yield _{1.0%} N/mm ²	Elongation A5%	Corrosion Tests	Hardness		
						HRB	HV	HRC
4505286-T	635	282		53		84 - 83		
Y506019-T	650	266		53		88		
4505044-T	675	307		39		83 - 83		
4505274-T	690	299		56		86 - 85		
4505271-T	700	324		54			188 - 186	
4505050-T	695	297		57			190 - 188	
4505393-T	680			60		86 - 85		

Surface and dimensions controlled:

Weld inspection

Signature



P60124PC001V 3042B .062X48 HT 4505271 4505050